

November-07-14 8:27:47 AM

Page 1

Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop ***NR2***

Date:

Draw Nbr	Revision Nbr	
D2224	Rev E	

B. = 15/02/18

5 0 08 0.00

1-Machine as per Folio D2224 & Dwg D2224-Deburr.

D. A 15/02/18

5 ϕ 08
9-89

0.00

B. e 15/02/2

08
9-89

Work Order ID 126418

126418

Page 2

November-07-14 8:27:47 AM

Item ID: D2224 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rappel Anchor Assembly
 Start Date: 07/11/2014 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 21/11/2014 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				5	0		DAS 37 9-99 15-02-22
130									
QC	Memo	0.00							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: 27605 Red Anodize as per Dwg D2224 MIL-A-8625								CD 15/02/22 (5)
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									DAS 06 9-99

5 MAR 04 2015

Work Order ID 126418

126418

Page 3

November-07-14 8:27:47 AM

Item ID: D2224 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rappel Anchor Assembly
 Start Date: 07/11/2014 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 21/11/2014 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo INSPECT ANODIZE	0.00 0.00				(5)			DAS 38 9-89 MAR 05 2015
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>st47</u> Memo	0.00 0.00				S			DAS 27 9-89 MAR 06 2015
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5			15-03-06 3.6

Picklist Print

November-07-14 8:27:46 AM

Page 1

Work Order ID: 126418

126418

Parent Item: D2224

D2224

Parent Item Name: Rappel Anchor Assembly

Start Date: 07/11/2014

Required Date: 21/11/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:D02.04.23Add note for grain direction & inspect 8, 21NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No				f	0.0000		2			

M7075T73B2 500X03 25

7075-T73 Bar 2.50 x 3.25

**

15/02/18

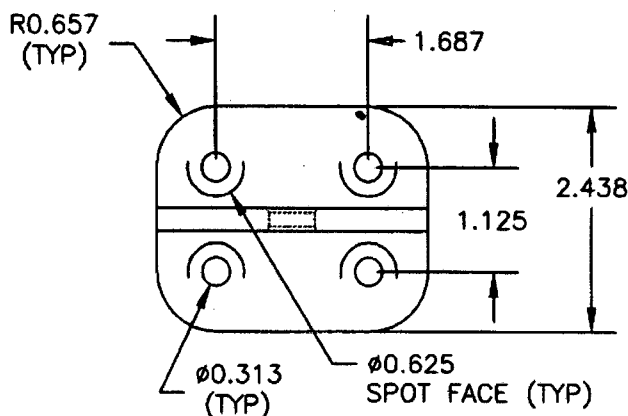
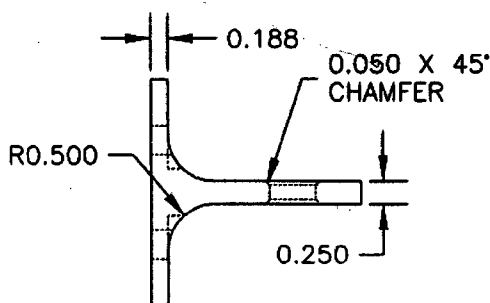
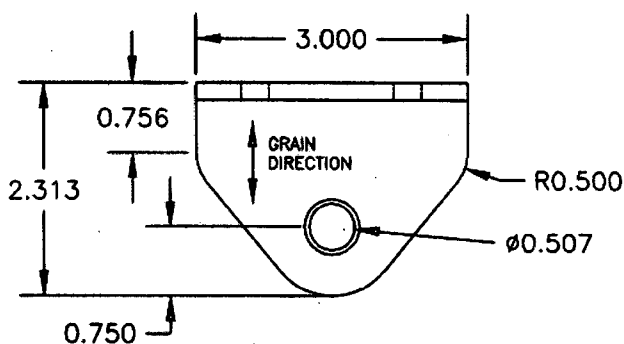
→ M131479

1.2 ft



RELEASED
99.05.11 KE

DESIGN HA	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED HA	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD		Work Order: 126418
Description: Rappel Anchor		Part Number: D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	0.190	✓		Mic	GA-03
0.050 x 45°	+/-0.010 x 0.5°	0.048 x 45°	✓		Vern	GA-13
0.250	+/-0.010	0.251	✓		Mic	118-120
R0.500	+/-0.010	R0.500	✓		R-6	ref.
3.000	+/-0.010	3.000	✓		Vern	GA-13
Ø0.507	+0.008/-0.001	Ø0.508	✓		"	"
0.750	+/-0.010	0.750	✓		"	"
2.313	+/-0.010	2.313	✓		"	"
1.687	+/-0.010	1.687	✓		"	"
2.438	+/-0.010	2.438	✓		"	"
1.125	+/-0.010	1.125	✓		"	"
Ø0.313	+0.006/-0.001	Ø0.314	✓		"	"

Measured by: J.A.	DAS 08	Audited by: 37	DAS 08	Prototype Approval:	N/A
Date: 15/02/21	9-85	Date: 15.02.22	9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63569

Date: 04-Mar-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 ea	Part: D2224 RAPPEL ANCHOR RED ANODIZE AS PER MIL-A-8625 TY II CL 2 MINMUM RUN Job: 20150185 5 PCS	Rev: Line:	PO: PO27605
6 ea	Part: D4726-1 HANDLE REV.A HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150186	Rev: Line:	PO: PO27605
4 ea	Part: 647.3917 DOUBLER HARD ANODIZE MIL-A-8625 TY III CL 2 PRIME MIL-P-23377J TYPE I CLASS N PRIMER SUPPLY CUSTOMER Job: 20150187	Rev: C Line:	PO: PO27605
16 ea	Part: 647.4111 DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150188	Rev: N/C Line:	PO: PO27605
6 ea	Part: 649.5310 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N	Rev:	



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HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity		Description	
		PRIMER IS SUPPLY BY CUSTOMER Job: 20150189 PO: PO27605 Line:	
4 ea	Part: 650.9201 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY CUSTOMER Job: 20150190 PO: PO27605 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>4/3/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 1 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	126418	D2224 RAPPEL ANCHOR REV. E	3/5/2015 Yes 3/5/2015 FINISH: RED ANODIZE AS PER MIL-A-8625F TYPE I OR IB / IC / II / IIB CLASS 2		5.00	\$25.00	\$125.00
Line Total:							\$125.00
2	128523	D4726-1 HANDLE REV. A	3/5/2015 Yes 3/5/2015 FINISH: BLACK ANODIZE AS PER MIL-8625F TYPE III, CLASS 2		6.00	\$2.70	\$16.20
Line Total:							\$16.20

Note:

3/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 2 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

3	130171	647.3917 DOUBLER REV. C	3/3/2015	4.00	\$6.60	\$26.40
---	--------	----------------------------	----------	------	--------	---------

Yes

3/3/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2

PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

RUSH ORDER NEED BY MARCH 3

Line Total: \$26.40

4	120743	647.4111 REV. N/C	3/5/2015	16.00	\$7.90	\$126.40
---	--------	-------------------	----------	-------	--------	----------

Yes

3/6/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2

PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Line Total: \$126.40

5	127876	649.5310 LOWER DEFLECTOR REV. C	3/5/2015	6.00	\$11.45	\$68.70
---	--------	------------------------------------	----------	------	---------	---------

Yes

3/5/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2

PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Note:

3/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 3 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$68.70

6	71401-45	PROCUREMENT QUALITY CLAUSES	3/3/2015	1.00	\$0.00	\$0.00
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No

Procurement Quality Clauses

3/3/2015

A004 FAA-PMA /TSO

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

7	129589	650.9201 EYELET BRACKET REV.N/C	3/4/2015	4.00	\$6.60	\$26.40
---	--------	------------------------------------	----------	------	--------	---------

Yes

3/4/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

15/03/04
SF

Note:

3/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 4 of 4

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$26.40

PO Total: \$389.10

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 3/3/2015

1	126418/D2224	RED ANODIZE	5	LOT 125.00	
2	128523/D4726-1	HARD ANODIZE BLACK	6	\$2.70	
3	130171/647.3917	HARD ANO BLACK/PRIME	4	\$6.60	
4	120743/647.4111	HARD ANO BLACK/PRIME	16	\$7.90	
5	127876/649.5310	HARD ANO BLACK/PRIME	6	\$11.45	
6	129589/650.9201	HARD ANO BLACK/PRIME	4	\$6.60	
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					

PO27605 QUOTE ONLY

ATG IS NOT DOING ANY Pretreatment as per cardinal's 4860-50 AND
PRETREAT PRC-DESOTO PR-148

Repeat order.